

Work Order ID **76172*****76172***

Page 1

Monday, November 07, 2011 12:59:39 PM

Item ID: D3294-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 11/7/2011 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/16/2011 Req'd Qty: 10.00 ***10*** Customer:
Reference:
Approvals: Process Plan: P Date: 11-11-07 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3294	Rev C								

100

0.00

100

Waterjet

FLOW CNC Waterjet

2004 OK

Memo

1-Cut as per Dwg D3294

CUt File D3294-3

Dwg Rev: CProg Rev: C

*grain direction on a 45 deg as per dwg**

2-Deburr if necessary

1311-12-12

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

AF1311-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8/11/12/12		(40)			
130 *130* Brake NC Brake NC	Memo 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)	0.00 0.00		SA 11/12/13		(15)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/11/12/14		(40)			

W/O:		WORK ORDER CHANGES					
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EP 11/12/14 (10)

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Required Date:	11/16/2011	Req'd Qty:	10.00	*10*	Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						NR1
						NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180		0.00							
QC	Memo								
Quality Control									
190	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
190		0.00							
Powdercoat									
Powder Coating									
	Memo								
	Start Time:								
	Oven Temperature:								
	Finish Time:								
200	QC3- Inspect Part Finish	0.00							
200		0.00							
QC	Memo								
Quality Control									

180
QC
Quality Control

190
190
Powdercoat
Powder Coating

200
200
QC
Quality Control

0.00 *Switz/14*

(X10)

10X0 M-11/12/14

10 BR 11-12/16

M 115128

4:00
Memo
Start Time: *3:20*
Oven Temperature: *320 OF*
Finish Time: *4:30*

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>212</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

11/12/2011
 (10)

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Picklist Print

Monday, November 07, 2011 12:59:44 PM

Page 1

Work Order ID: 76172

76172

Parent Item: D3294-1

D3294-1

Parent Item Name: Bracket

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A04.08.24New issueKJ/JLM
IPP Rev:B Now On Waterjet 07-03-26 JLM
IPP Rev:C 08-07-16 Redesign part DD verified by:EC
IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S 080		Purchased	No			100	sf	204.3000	1.8	18.94737			

M2024T3S 080

B 11-12-12

2024-T3 080 sheet 1

Location	Loc Qty	Loc Code
MAT022	204.3	
105411	6	
109424	4	
110347	0.5	
112331	3	
113796	7	
114025	15.7	
116604	5.8	
117392	40.1	
118180	49.7	
119117	72.5	

D3294-5

Manufactured No

170 Each

1.0000

1

10

D3294-5

Doubler

Location	Loc Qty	Loc Code
GA	1	
69525	1	

A117392

B 11/12/14

B74524
(107)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 76172

76172

Parent Item: D3294-1

D3294-1

Parent Item Name: Bracket

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 10.00

Required Qty: 10.00

MS20470AD4-5

Purchased

No

170

Each

2,424.000

15

150

MS20470AD4-5

Rivet, Universal Head

**

Handwritten signature and date: 11/12/14

Location

Loc Qty

Loc Code

ST319

2424

116893

68

118405

2356

150

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	76172
Description: Bracket Assembly		Part Number:	D3294-1
Inspection Dwg: D3294	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.132	2		✓ Bo2	
Ø0.141	+0.005/-0.001	.146	2		✓	
6.708	+/-0.010	6.711	✓		✓	
1.118	+/-0.010	1.117	✓		✓	
5.590	+/-0.010	5.592	✓		✓	
1.118	+/-0.010	1.118	2		✓	
13.563	+/-0.010	13.563	2		T Bo1	
1.043	+/-0.010	1.044	2		✓	
0.625	+/-0.010	.625	2		✓	
0.325	+/-0.010	.327	2		✓	
0.300	+/-0.010	.301	✓		✓	
0.400	+/-0.010	.402	2		✓	
6.000	+/-0.010	6.003	2		✓	
1.000	+/-0.010	.999	2		✓	
17.124	+/-0.010	17.124	2		T	
16.13	+/-0.030	16.13	2		T	
7.27	+/-0.030	7.27	2		T	
11.97	+/-0.030	11.97	2		T	
8.37	+/-0.030	8.37	2		T	
20.05	+/-0.030	20.05	2		T	
12.98	+/-0.030	12.98	2		T	
14.59	+/-0.030	14.59	2		T	
11.66	+/-0.030	11.66	2		T	
0.080	+/-0.010	.079	2		✓	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-12-12	Date:	11/12/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	

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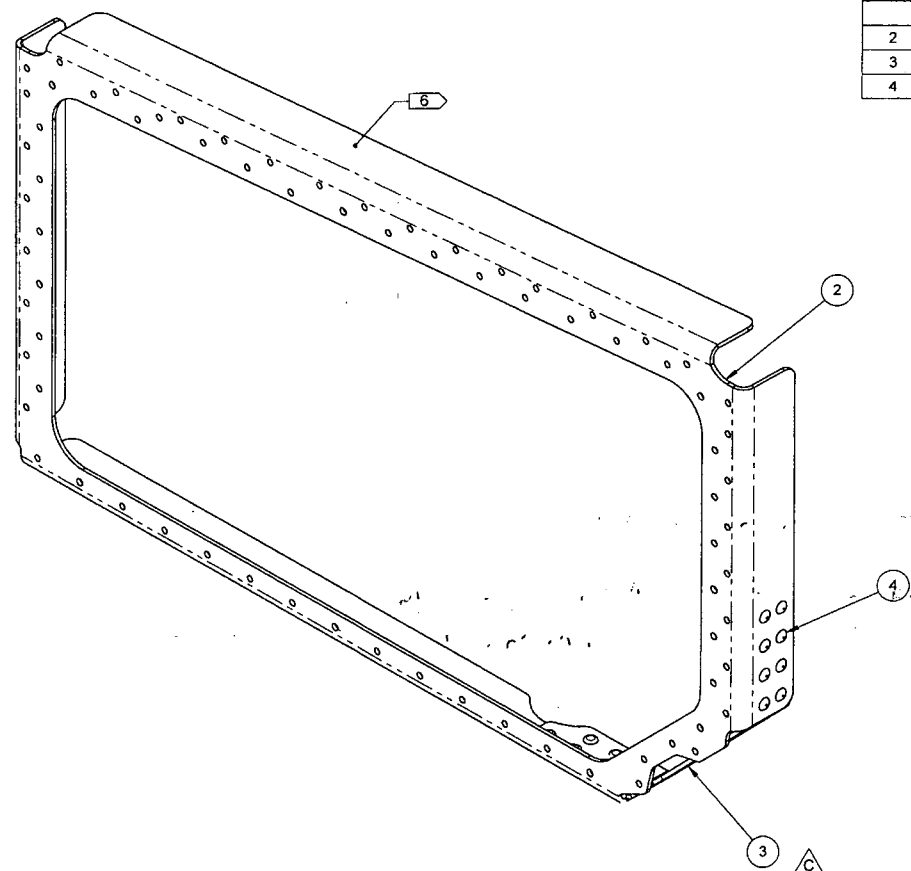
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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76472

11-11-07

RELEASED
09/07/07

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3294 TITLE BRACKET REV. C SHEET 1 OF 6 SCALE NTS <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.03.24		

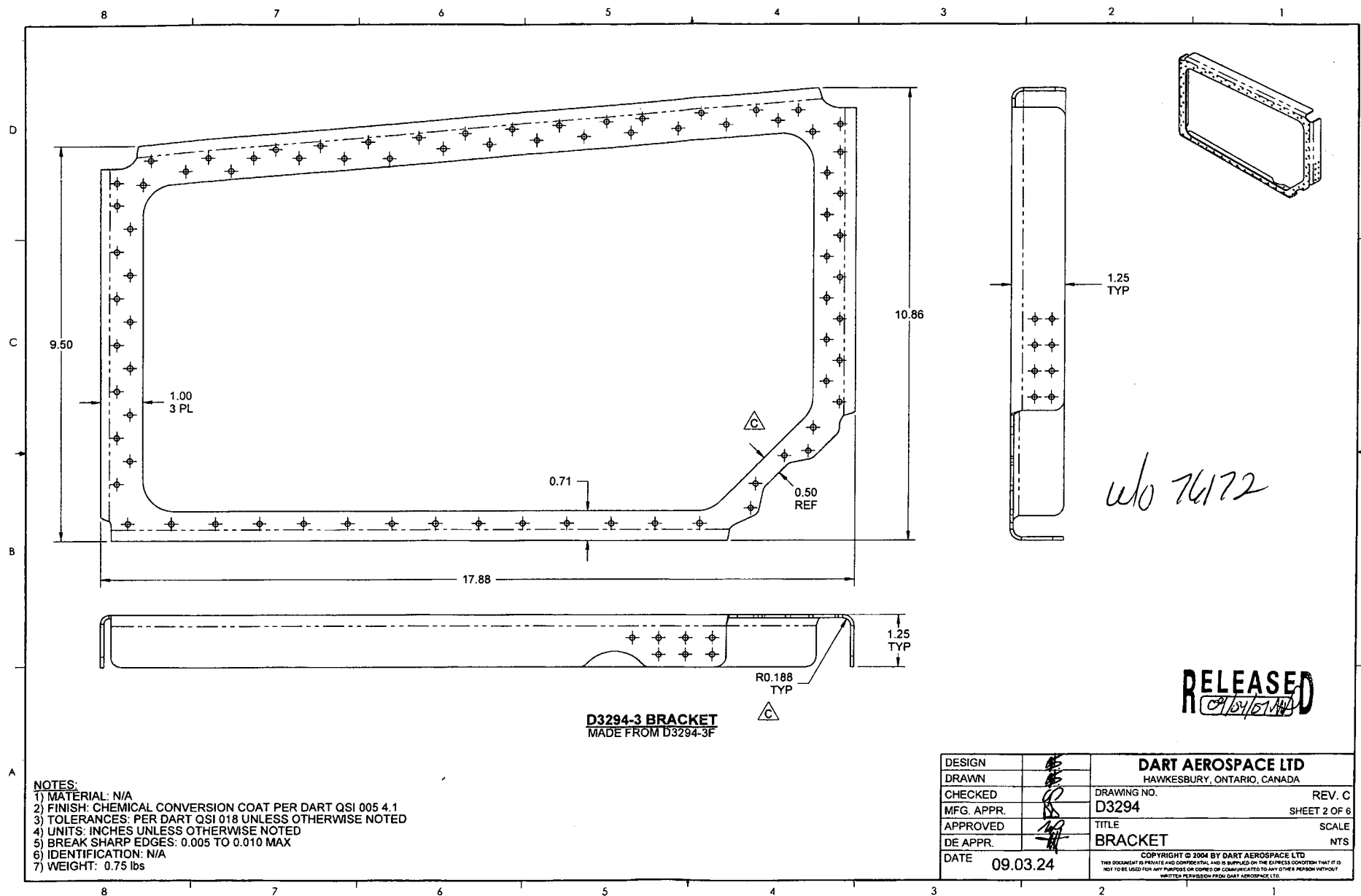
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NOTE: Date & initial all entries



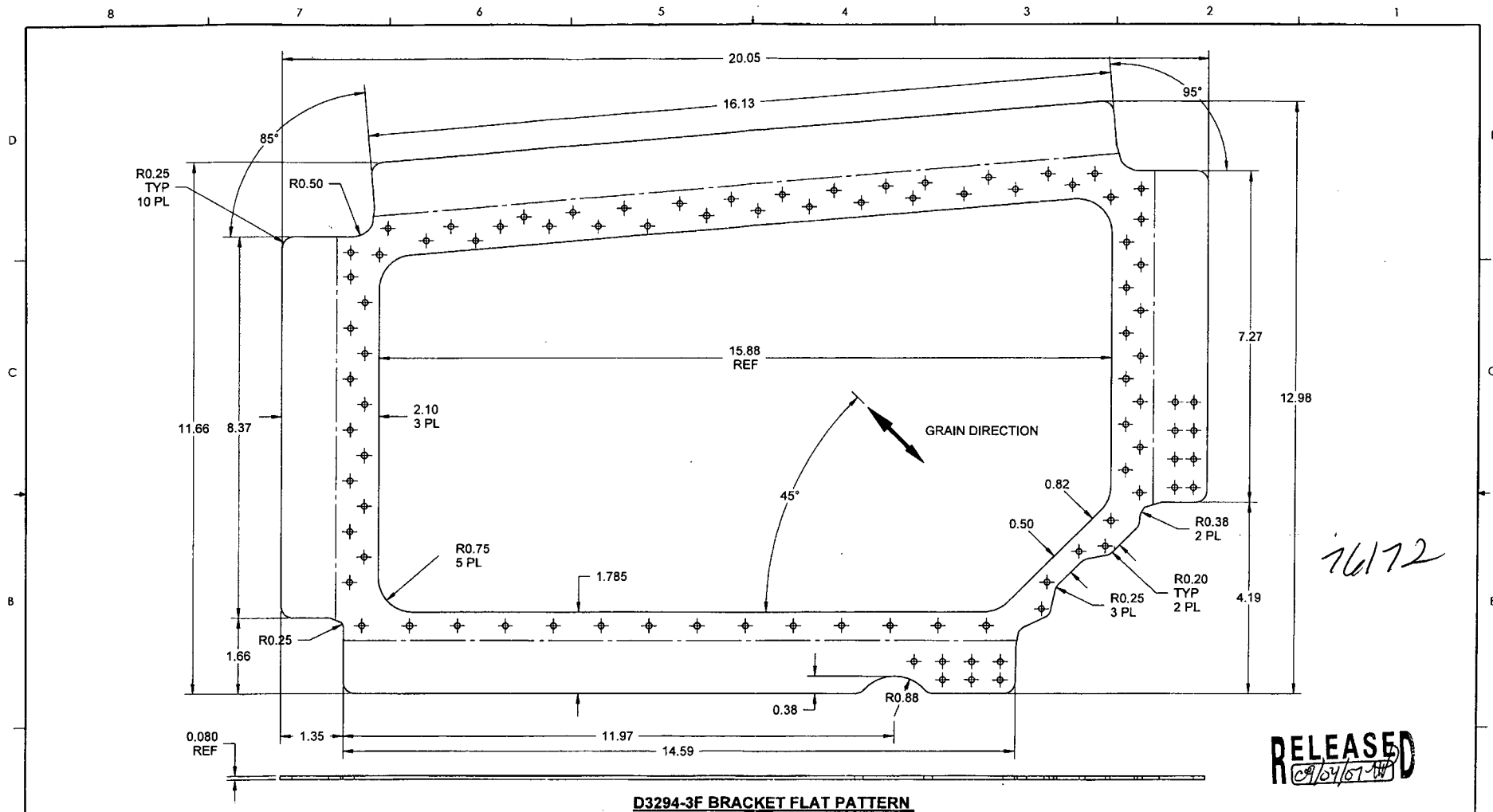
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NOTE: Date & initial all entries



D3294-3F BRACKET FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.03.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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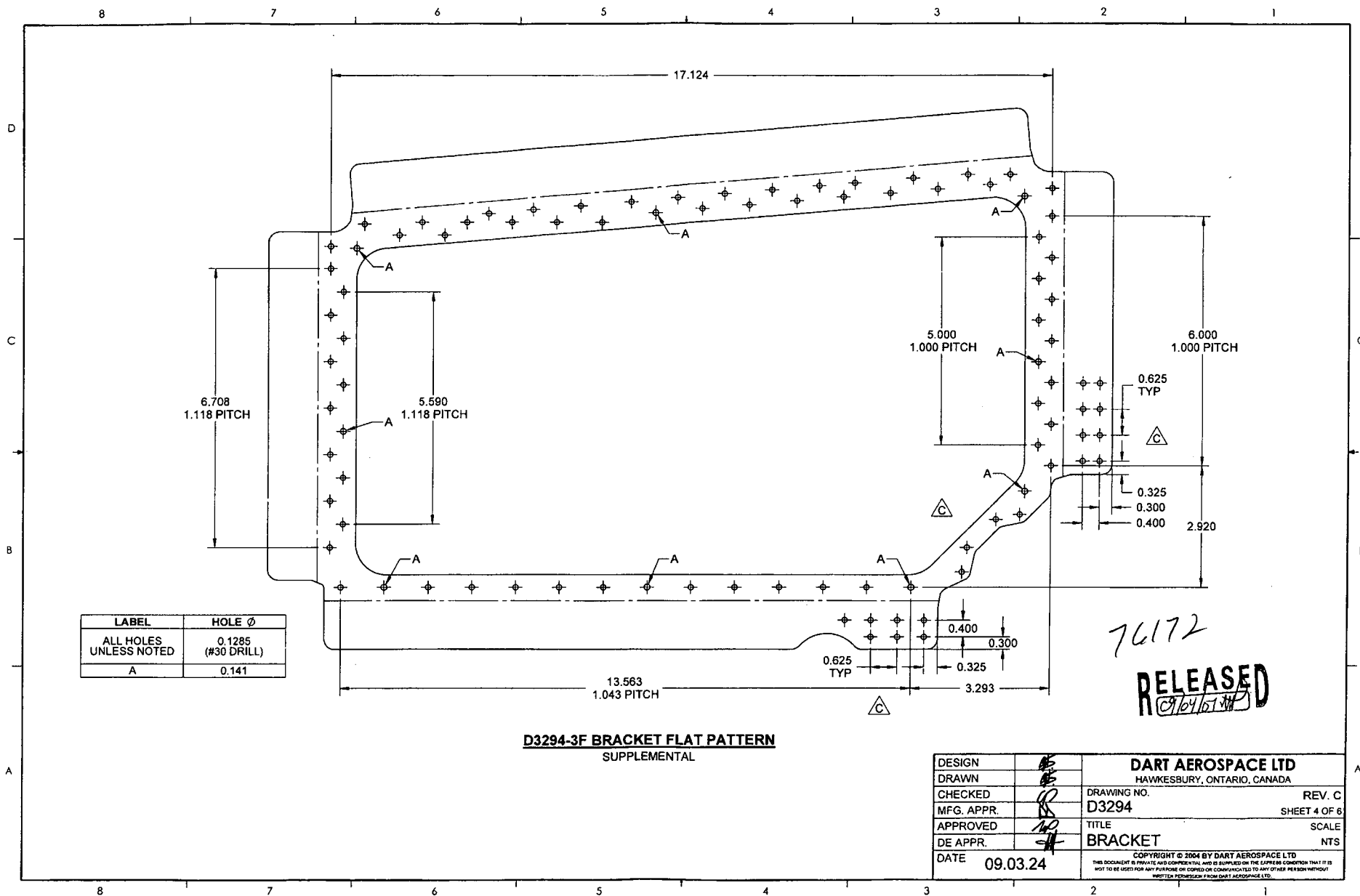
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76172
RELEASED
07/15/17

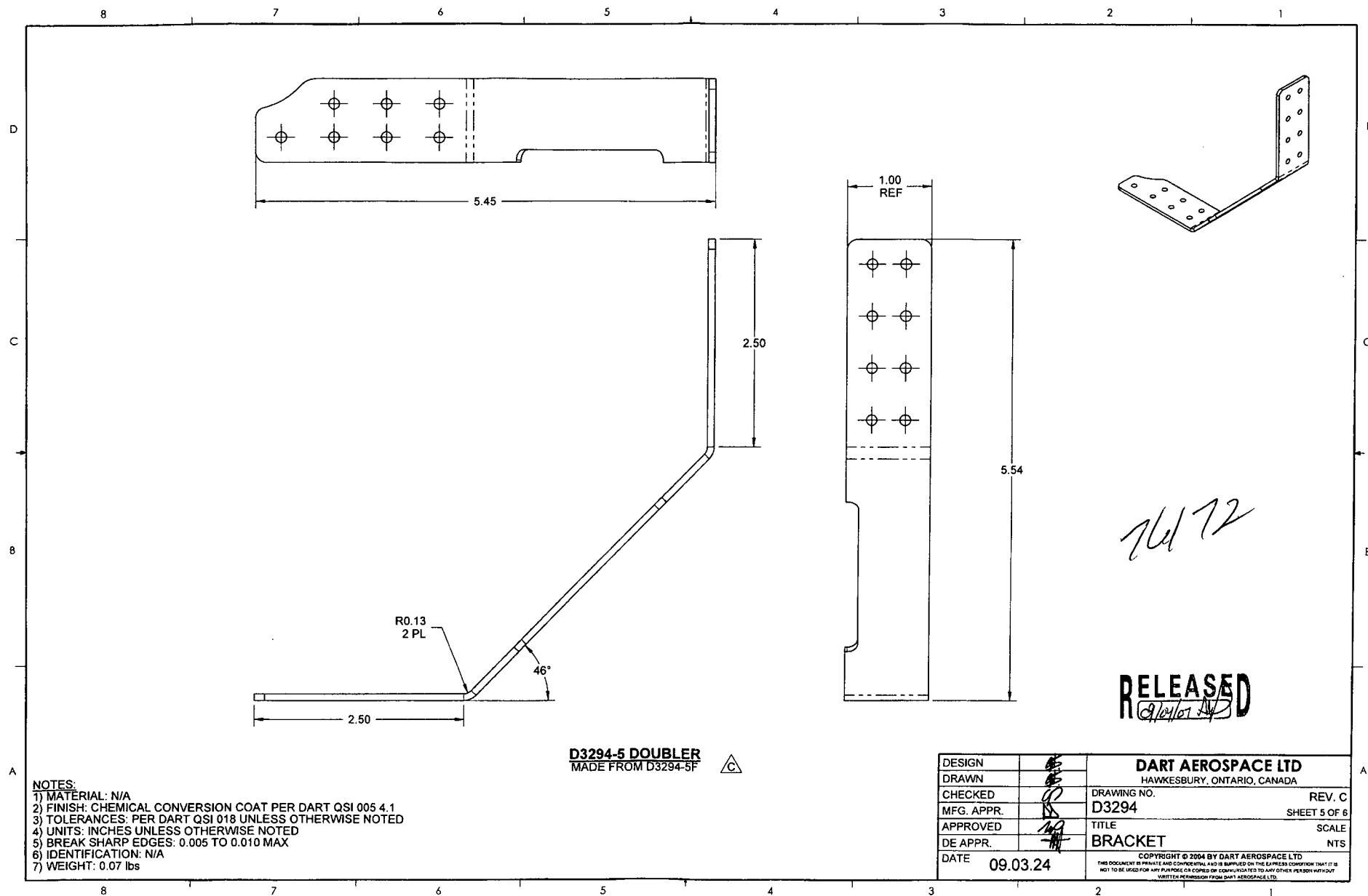
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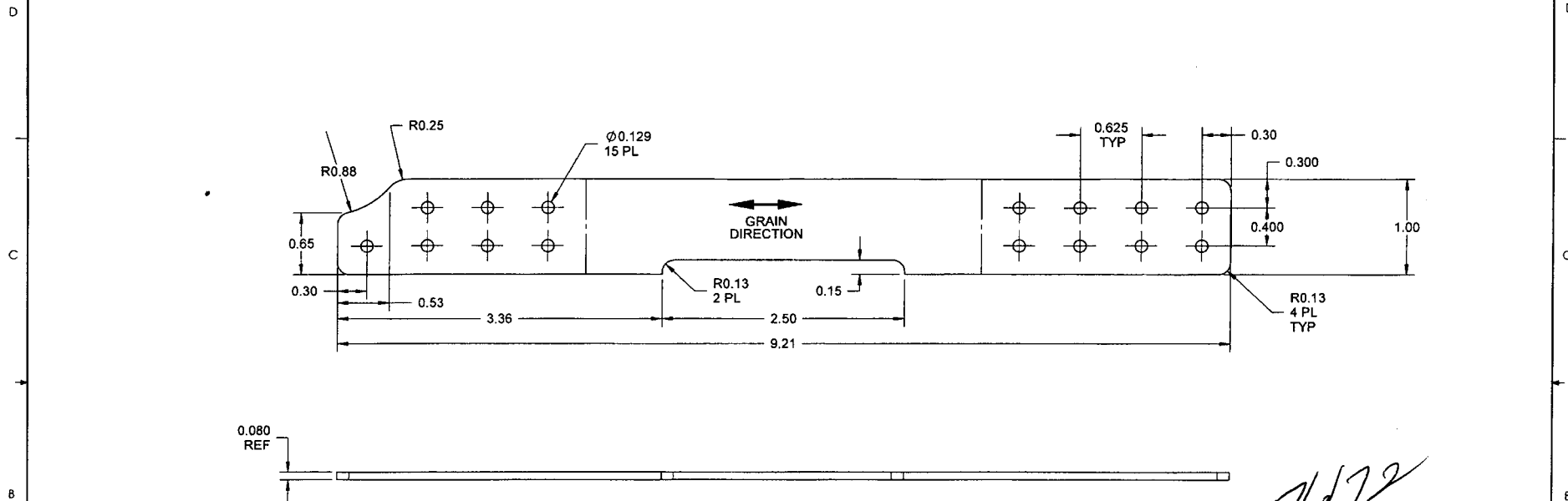
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8 7 6 5 4 3 2 1



7d72

D3294-5F DOUBLER FLAT PATTERN



RELEASED
09/04/07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 LBS

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			D3294	SHEET 6 OF 6
APPROVED			TITLE	SCALE
DE APPR.			BRACKET	NTS
DATE	09.03.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD		
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8 7 6 5 4 3 2 1

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